

Work Order ID 74544 - 2



Page 1

Tuesday, October 04, 2011 9:49:59 AM

Item ID: K642-511

Revision ID:

Item Name: saddle kit 642-511

Start Date: 9/30/2011 Start Qty: 3.00

Required Date: 10/14/2011 Req'd Qty: 3.00

Reference:

Approvals:

Process Plan: M.L.J

Date: 11/10/04 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

DSI 9467

Rev A

IIN D206-642

Rev N

100

0.00



DC

Document Control

DOCUMENT CONTROL

Memo

Create White labels per PPP K642-511

CHG004

110

0.00



Packaging

Packaging

Pick Kit

Memo

0.00

11/12/09 12/1/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 74544

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Page 2

Item ID: K642-511

Accept



Setup Start



Revision ID:

Stop



Item Name: saddle kit 642-511

Start Date: 9/30/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 3.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC4- 100% Inspect kits for completeness

0.00

8/21/02/05

(x2)



QC

Memo

0.00

Quality Control

130

Packaging

0.00

0.00



Packaging

Memo

Identify and pack for shipping as per PPP K642-511 Location:

pk

Raw B

26/7

(20)

140

QC21- Final Inspection - Work Order Release

0.00

0.00



QC

Memo

Quality Control

12/2/8

mf
12-02-07

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Picklist Print

Tuesday, October 04, 2011 9:50:04 AM

Page 1
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Work Order ID: 74544

Parent Item: K642-511

Parent Item Name: saddle kit 642-511



Start Date: 9/30/2011

Required Date: 10/14/2011

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A 07.06.05 new issue EC
IPP Rev.B 08.02.05 Per ECN1080P LL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN3C35A

Purchased

No

110

Each

73.0000

3

9



BOLT

Location

Loc Qty

Loc Code

FG

4

18914

4

ST353

69

118628

19

119125

50

AN3C36A

Purchased

No

110

Each

92.0000

9

27



BOLT

Location

Loc Qty

Loc Code

FG

14

101261

4

116590

10

ST353

78

118757

36

119083

12

119125

30

AN3C41A

Purchased

No

110

Each

84.0000

8

24



BOLT

Location

Loc Qty

Loc Code

FG

4

103324

4

ST354

80

119035

80

119530

1119035 12/1/2011

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Tuesday, October 04, 2011 9:50:04 AM

Work Order ID: 74544

Parent Item: K642-511

Parent Item Name: saddle kit 642-511



Start Date: 9/30/2011

Required Date: 10/14/2011

Start Qty: 3.00

Required Qty: 3.00

AN4C6A

Purchased

No

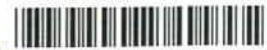
110

Each

242.0000

12

36



Bolt

Location

Loc Qty

Loc Code

FG

4

103344

4

ST356

238

116704

15

118451

123

118983

100

AN5C11A

Purchased

No

110

Each

152.0000

8

24



Bolt

Location

Loc Qty

Loc Code

FG

4

104817

4

ST337

148

~~118706~~

48

~~118983~~

50

119127

50

AN5C12A

Purchased

No

110

Each

52.0000

4

12



BOLT

Location

Loc Qty

Loc Code

FG

2

18918

2

ST338

50

118451

10

118983

40

Tuesday, October 04, 2011 9:50:04 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Work Order ID: 74544

Parent Item: K642-511

Parent Item Name: saddle kit 642-511

Start Date: 9/30/2011

Required Date: 10/14/2011

Start Qty: 3.00

Required Qty: 3.00

AN5C13A

Purchased

No

110

Each

103.0000

4

12



BOLT

Location

Loc Qty

Loc Code

ST338

103

117872

28

118983

75

AN5C15A

Purchased

No

110

Each

65.0000

1

3



Bolt

Location

Loc Qty

Loc Code

ST338

15

118191

15

ST339

50

118267

50

AN5C32A

Purchased

No

110

Each

111.0000

2

6



Location

Loc Qty

Loc Code

FG

4

18918

4

ST339

50

119035

50

ST340

57

116380

7

117407

25

117969

25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item: K642-511

Parent Item Name: saddle kit 642-511

Start Date: 9/30/2011

Required Date: 10/14/2011

Start Qty: 3.00

Required Qty: 3.00

52

AN5C34A

Purchased

No

110

Each

51.0000

2 6



6

Location

Loc Qty

Loc Code

FG

2

18918

2

ST339

20

119083

20

ST340

29

117950

18

118985

11

6

52

AN5C35A

Purchased

No

110

Each

47.0000

1 3



3

Location

Loc Qty

Loc Code

ST340

22

108407

22

ST341

25

118451

25

3

52

AN960C10L

NAS1149C0332

Purchased

No

110

Each

0.0000

24 72



washer

M119730

52

AN960C416L

Purchased

No

110

Each

0.0000

24 72



M117091

WASHER

52

AN960C516L

NAS1149C0532

Purchased

No

110

Each

0.0000

8 24



M118384 M112512

WASHER

Tuesday, October 04, 2011 9:50:04 AM

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Page 4

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 74544

Parent Item: K642-511

Parent Item Name: saddle kit 642-511

Start Date: 9/30/2011

Required Date: 10/14/2011

Start Qty: 3.00

Required Qty: 3.00

D206-648-013

415602

Manufactured

No

110

Each

0.0000

1 3



GHW Modification

D2652

Manufactured

No

110

Each

755.0000

16 48



Bushing

Location

Loc Qty

Loc Code

FG

44

31985

44

ST019

711

73755

100

73833

611

D2712

Manufactured

No

110

Each

1,291.000

10 30



Set Screw

Location

Loc Qty

Loc Code

FG

50

29962

50

ST021

1241

71160

1

72231

240

73837

1000

D2932-1

Manufactured

No

110

Each

10.0000

1 3



Saddle LH Out, 206

Location

Loc Qty

Loc Code

ST428

10

72886

4

73466

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 74544

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Parent Item Name: saddle kit 642-511

Start Date: 9/30/2011

Required Date: 10/14/2011

Start Qty: 3.00

Required Qty: 3.00

D2933-1

Manufactured No

110 Each

3.0000

1 3

2 12/2/6
B76191

Saddle LH In, 206

Location

Loc Qty

Loc Code

ST428

3

72884

3

D2934

Manufactured No

110 Each

6.0000

2 6

B74501

Saddle Spacer

Location

Loc Qty

Loc Code

FG

6

31929

6

D2935

Manufactured No

110 Each

0.0000

2 6

B74503 12/1/2

Saddle Spacer

D2938-1

Manufactured No

110 Each

4.0000

1 3

B75098 12/1/17

Saddle LH Out, 206

Location

Loc Qty

Loc Code

ST428A

4

73468

4

D2939-1

Manufactured No

110 Each

4.0000

1 3

12/1/2 2
B75099 12/1/17

Saddle LH In, 206

Location

Loc Qty

Loc Code

ST428A

4

73448

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Tuesday, October 04, 2011 9:50:05 AM

Work Order ID: 74544

Parent Item: K642-511

Parent Item Name: saddle kit 642-511

Start Date: 9/30/2011

Required Date: 10/14/2011

Start Qty: 3.00

Required Qty: 3.00

D3396-3

Manufactured No

110

Each

81.0000

2

6



Spacer

Location

Loc Qty

Loc Code

FG

10

26772

10

ST052

71

73349

71

Manufactured No

110

Each

13.0000

1

3

D3407-043



Tow Ring

Location

Loc Qty

Loc Code

ST463

11

73341

11

ST464

2

68339

2

Manufactured No

110

Each

118.0000

1

3

D3456-1



Washer

Location

Loc Qty

Loc Code

FG

7

25701

7

ST054

111

66848

3

71165

8

73493

100

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Tuesday, October 04, 2011 9:50:05 AM

Work Order ID: 74544

Parent Item: K642-511

Parent Item Name: saddle kit 642-511

Start Date: 9/30/2011

Required Date: 10/14/2011

Start Qty: 3.00

Required Qty: 3.00

D3457-1

Manufactured No

110

Each

28.0000

2

6



Washer

Location

Loc Qty

Loc Code

FG

10

32409

10

ST054

18

67779

1

71849

17

D3672-1

Manufactured No

110

Each

886.0000

24

72



Phenolic Washer

Location

Loc Qty

Loc Code

ST074

884

64177

58

66821

466

72229

360

ST077

2

52505

2

D3672-3

Manufactured No

110

Each

867.0000

24

72



Phenolic Washer

Location

Loc Qty

Loc Code

ST074

867

64176

180

72230

187

73487

500

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Tuesday, October 04, 2011 9:50:05 AM

Work Order ID: 74544

Parent Item: K642-511

Parent Item Name: saddle kit 642-511

Start Date: 9/30/2011

Required Date: 10/14/2011

Start Qty: 3.00

Required Qty: 3.00

D3672-7

Manufactured No

110 Each

578.0000

24

72



Phenolic Washer

Location

Loc Qty

Loc Code

ST074

578

53237

244

64175

50

73488

284

Purchased No

110 Each

979.0000

20

60

MS21043-3



Nut

Location

Loc Qty

Loc Code

FG

72

103691

72

ST301

907

118077

1

118614

492

118686

414

Purchased No

110 Each

845.0000

13

39

MS21043-4



Nut

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

805

117793

305

118686

500

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W/O:		WORK ORDER CHANGES					
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Work Order ID: 74544



Parent Item: K642-511



Parent Item Name: saddle kit 642-511

Start Date: 9/30/2011

Required Date: 10/14/2011

Start Qty: 3.00

Required Qty: 3.00

MS21043-5

Purchased

No

110

Each

424.0000

4

12



Nut



11/26/29 J B

Location

Loc Qty

Loc Code

FG

20

101418

20

ST301

304

112314

204

116548

100

ST314

100

118159

100

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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4.7 206L/L-1/L-3/L-4/407 HIGH GEAR FLOAT SKIDTUBES (TRI-BAG COMPATIBLE)

ITEM	QTY -511	QTY -512	QTY -515	QTY -516	QTY -541	QTY -547	QTY -549	QTY -551	QTY -013	PART NUMBER	DESCRIPTION
	X									D206-642-511	SKIDTUBE INSTALLATION, LH
		X								D206-642-512	SKIDTUBE INSTALLATION, RH
			X							D206-642-515	SKIDTUBE INSTALLATION, LH
				X						D206-642-516	SKIDTUBE INSTALLATION, RH
1	1	1			X					D206-642-541	SKIDTUBE
						X				D206-642-547	WEARSHOE KIT (REPLACES -543 KIT)
							X			D206-642-549	RUN-ON LANDING WEARPLATE KIT
			1	1				X		D206-642-551	SKIDTUBE
	1	1	1	1					X	D206-648-013	GROUND HANDLING KIT
1					1					D3274-041	SKIDTUBE ASSEMBLY
1								1		D4362-041	SKIDTUBE ASSEMBLY
3					1			1		D2646	* AFT CAP ⁽¹⁾
4					2			2		AN3C4A	* BOLT ⁽¹⁾
5A					2			2		NAS1149C0332R	* WASHER ⁽¹⁾ (OR AN960C10L)
5B					2			2		D3672-1	* WASHER (REPLACES NAS1515H3L) ⁽¹⁾
6	1		1							D2932-1	SADDLE, FWD OUT, LH
6		1		1						D2932-2	SADDLE, FWD OUT, RH
7	1		1							D2933-1	SADDLE, FWD IN, LH
7		1		1						D2933-2	SADDLE, FWD IN, RH
8	1		1							D2938-1	SADDLE, AFT OUT, LH
8		1		1						D2938-2	SADDLE, AFT OUT, RH
9	1		1							D2939-1	SADDLE, AFT IN, LH
9		1		1						D2939-2	SADDLE, AFT IN, RH
10	8	8	8	8						AN3C41A	BOLT
11	16	16	16	16						D2652	BUSHING
12A	8	8	8	8						MS21043-3	NUT
12B	16	16	16	16						D3672-7	WASHER (REPLACES NAS1515H5)
13	4	4	4	4						AN5C11A (or AN5C12A)	* BOLT ⁽²⁾
14	4	4	4	4						AN5C11A (or AN5C13A)	* BOLT ⁽²⁾
15A	8	8	8	8						NAS1149C0532R	WASHER (OR AN960C516L)
15B	8	8	8	8						D3672-7	WASHER (REPLACES NAS1515H5L)
16	12	12	12	12						AN4C6A	BOLT
17A	24	24	24	24						D3672-3	WASHER (REPLACES NAS1515H4L)
17B	24	24	24	24						NAS1149C0432R	WASHER (OR AN960C416L)
18	12	12	12	12						MS21043-4	NUT
20A					9	9				D3537-1	* WEARPAD ⁽¹⁾ (REPLACES D2648-3)
21A					1	1				D3537-3	* WEARPAD ⁽¹⁾ (REPLACES D3429-1)
22A					1	1				D3535-15	* WEARSHOE ⁽¹⁾ (REPLACES D2656-15)
22B					1	1				D3536-15	* GASKET ⁽¹⁾
23A					1	1				D3535-23	* WEARSHOE ⁽¹⁾ (REPLACES D2656-23)
23B					1	1				D3536-23	* GASKET ⁽¹⁾
24A					1	1				D3535-39	* WEARSHOE ⁽¹⁾ (REPLACES D3287-1)
24B					1	1				D3536-39	* GASKET ⁽¹⁾
25A					1	1				D3535-35	* WEARSHOE ⁽¹⁾ (REPLACES D2656-35)
25B					1	1				D3536-35	* GASKET ⁽¹⁾
26A			8	8	78	78	8			AN3C4A	* BOLT ⁽¹⁾
26B			8	8	78	78	8			NAS1149C0332R	* WASHER ⁽¹⁾ (OR AN960C10L)
26C			8	8	78		8			ALS7-1032-130	* INSERT ⁽¹⁾ (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
30	1	1	1	1						D3407-043	TOW RING
32A	1	1	1	1						D3456-1	WASHER
32B	2	2	2	2						D3457-1	WASHER
33	1	1	1	1						MS21043-4	NUT
34			1	1	1					AN4C5A	BOLT
35			1	1	1					NAS1149C0463R	WASHER (OR AN960C416)
36			1	1	1					D3413-1	RING
37	10	10	10	10						D2712	SET SCREW
38	2	2	2	2						D2934	SADDLE SPACER
39	2	2	2	2						D2935	SADDLE SPACER

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ITEM	QTY -511	QTY -512	QTY -515	QTY -516	QTY -541	QTY -547	QTY -549	QTY -551	QTY -013	PART NUMBER	DESCRIPTION
40									2	D3414-041	LUG ASSEMBLY (GHW)
41									4	AN3C37A	BOLT
42									8	D2652	BUSHING
43									4	MS21043-3	NUT
44									4	NAS1149C0363R	WASHER (OR AN960C10)
50	9	9	3	3						AN3C36A	BOLT
51	3	3	3	3						AN3C35A	BOLT
52	24	24	12	12						NAS1149C0332R	WASHER (OR AN960C10L)
53	24	24	12	12						D3672-1	WASHER (REPLACES NAS1515H3L)
54	12	12	6	6						MS21043-3	NUT
55	2	2	2	2						D3396-3	SPACER
56A	1	1	1	1						AN5C35A	BOLT
56B	1	1	1	1						AN5C15A	BOLT
60	2	2	2	2						AN5C32A	BOLT
61	2	2	2	2						AN5C34A	BOLT
62	4	4	4	4						MS21043-5	NUT
80							1	1		D4368-041	FWD WEARPLATE ASSY
81							1	1		D4368-043	AFT WEARPLATE ASSY
82A							1	1		D4383-1	WEARPAD
82B							1	1		D4383-3	WEARPAD
83							20	20		D3873-3	BUSHING
84								24		D3411-3	WASHER
85							2			D3275-1	SPACER
86A							6	6		AN3C40A	BOLT
86B							2	2		AN3C37A	BOLT
86C							2	2		AN3C36A	BOLT
87							10	10		MS21043-3	NUT

NOTES: (1) DENOTES THAT PART IS INCLUDED WITH D3274-041 OR D4362-041 ASSEMBLY ABOVE
 (2) CHOICE OF BOLT WILL DEPEND ON CROSSTUBE (SEE INSTALLATION PROCEDURE)

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